



Dart Aerospace Ltd.
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Canada

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D3849-1**Job Sheet 202986****Part No:** D3849-1**Job Qty:** 6**Part Name:** Plate**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/7/19**Job Tracking No:****Due Date:** 11/15/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D3849 rev.G IPP REV:A NEW ISF 12-08-23 JLM VERIFIED BY:DD IPP Rev:B 12.09.11 AS PER
DWG REV.D DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs	11/15/19	11/15/19	0.17	1.77	Waterjet - Flow		JRB 12/3/19
110	QC 2	6 pcs	11/15/19	11/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

PRIORITY

DART AEROSPACE LTD.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S236785**Part:** D3849-1**Job No:** 202986**Serial No/Batch:** S236785**Revision:** REV.G**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 12/03/19

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120 QC 8	6 pcs	11/15/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	JRB 12/3/19
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS DEC 01 2019 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	6 pcs	11/15/19	0.25 0.77	Small Fab - Brake - 1 - B4B	DAS 30 9-89 DEC 13 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
210 QC 5	6 pcs	11/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS DEC 13 2019 40 9-89
				QC 5 - 61	
				QC 5 - 81	
220 Packaging 3-1 - Stock - B4B	6 pcs	11/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	GA
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
230 QC 21 - SA	6 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAG
				QC 21 - SA - 53	21 8-53
Part Op 100 - 1-Cut as per Dwg D3849 Dwg Rev: <u>G</u>				Prog Rev: <u>G</u> 2-Debur if necessary	
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)				DEC 16 2010	
120 - (QC8- Inspect parts - second check)					
130 - (Form as per dwg) Form as per dwg using DT8179 & DT8155 BEND AS PER SECTION E-E					
210 - (QC5- Inspect part completeness to step on W/O)					
220 - (Identify as per dwg & Stock Location: <u>W1002-1</u>)					
230 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S18GA	304/316 .050 Sheet	21.5100 sf (3.585 ea)	100-Waterjet - Flow - 1	5227406x8 5232151x4	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S18GA	22	88	0	
Part Specifications					
Specifications could not be found.					

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Entered: _____ Date: _____



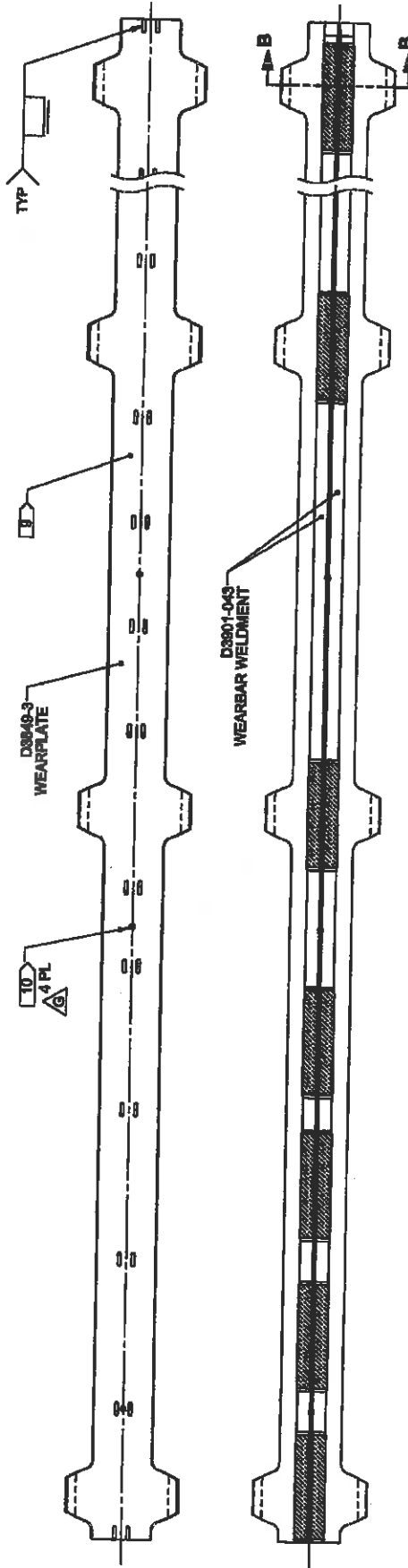
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

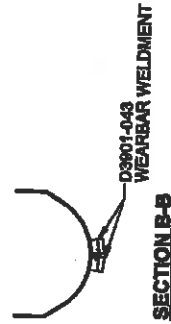
Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube Machining Large Fab ☐ ☐ ☐ Cross tube Small Fab Finishing ☐ ☐ ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging ☐ ☐ ☐		Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY			
				Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐			
				Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ Other/Details: _____			
Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐				Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐			
Completed By				Lead hand / Supervisor			
QC / QA Coordinator							

QTY	PIN	DESCRIPTION
1	D3849-043	AFT WEARPLATE ASSY, STD GEAR
1	D3849-3	WEARPLATE
2	D3801-043	WEARBAR WELDMENT



D3849-043 AFT WEARPLATE ASSY, STD GEAR



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 0.1
 - 7) WEIGHT: 0.01 lb
 - 8) WELDING: PER QSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9.
 - 10) TRANSFER DRILL, Ø0.188 HOLES FROM D3849-3 WEARPLATE TO D3801-043 WEARBARS, AFTER APPLYING TEXTURED COATING.

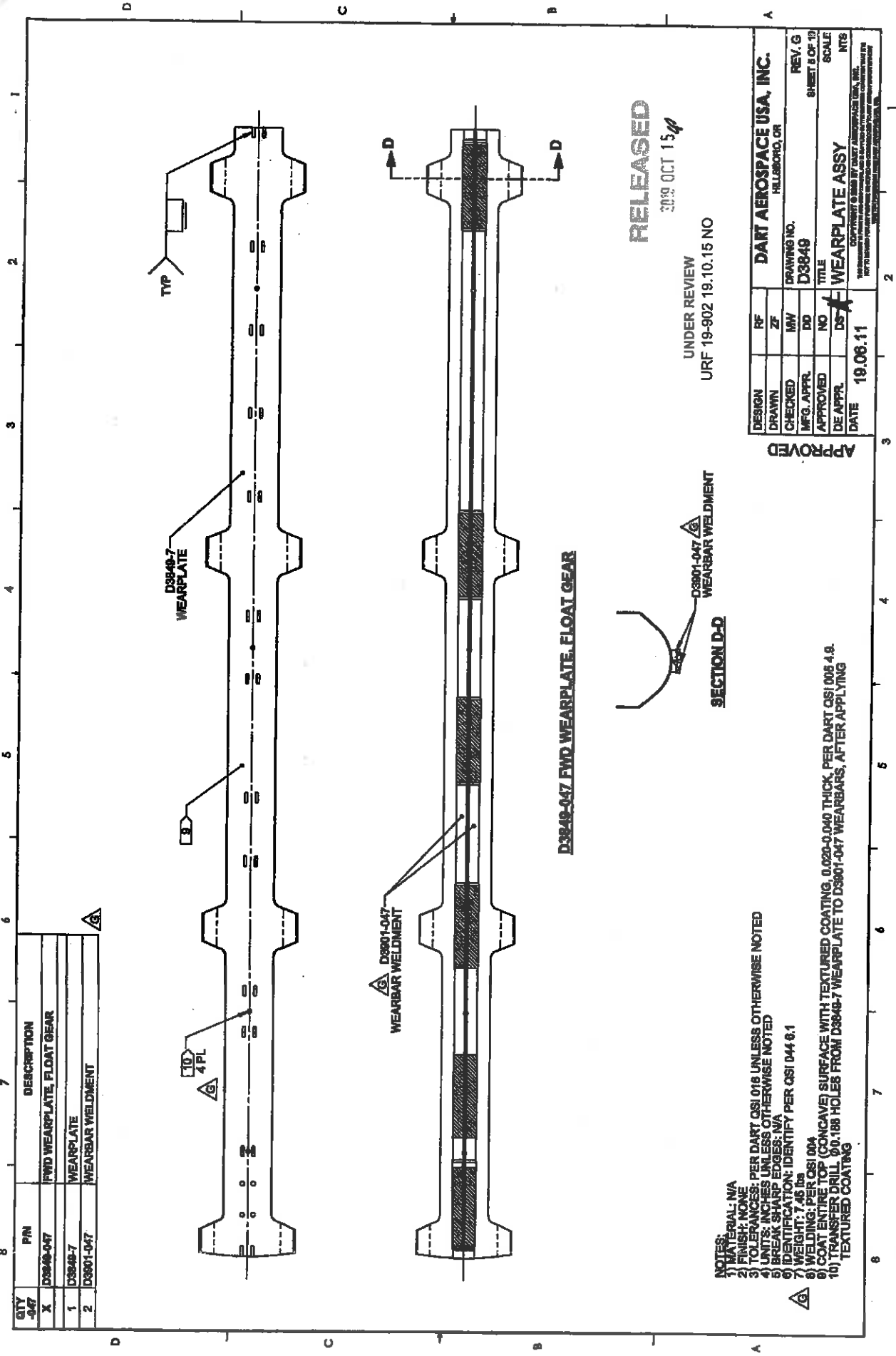
RELEASED

2019 OCT 15

UNDER REVIEW
URF 19-802 19.10.15 NO

DESIGN	RF	DATE	19.06.11
DRAWN	ZF		
CHECKED	MM		
INFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS		
DART AEROSPACE USA, INC. HILLSBORO, OR			
DRAWING NO. D3849			
REV. G			
SHEET 3 OF 10			
TITLE WEARPLATE ASSY			
SCALE NTS			

APPROVED



QTY	PIN	DESCRIPTION
X	D3849-047	FWD WEARPLATE, FLOAT GEAR
1	D3848-7	WEARPLATE
2	D3801-047	WEARBAR WELDMENT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 8.1
 - 7) WEIGHT: 7.45 lbs
 - 8) WELDING: PER QSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 006 4.9.
 - 10) TRANSFER DRILL 0.0188 HOLES FROM D3848-7 WEARPLATE TO D3801-047 WEARBARS, AFTER APPLYING TEXTURED COATING

DESIGN	RF	DATE	19.06.11
DRAWN	ZF		
CHECKED	MM		
MFG. APPL.	DD		
APPROVED	NO		
DE APPL.	DS		
DATE	19.06.11		

DESIGN NO.	D3849	REV. G
DRAWING NO.	D3849	SHEET 6 OF 10
TITLE	WEARPLATE ASSY	SCALE
		NTS

DART AEROSPACE USA, INC.
HILLSBORO, OR

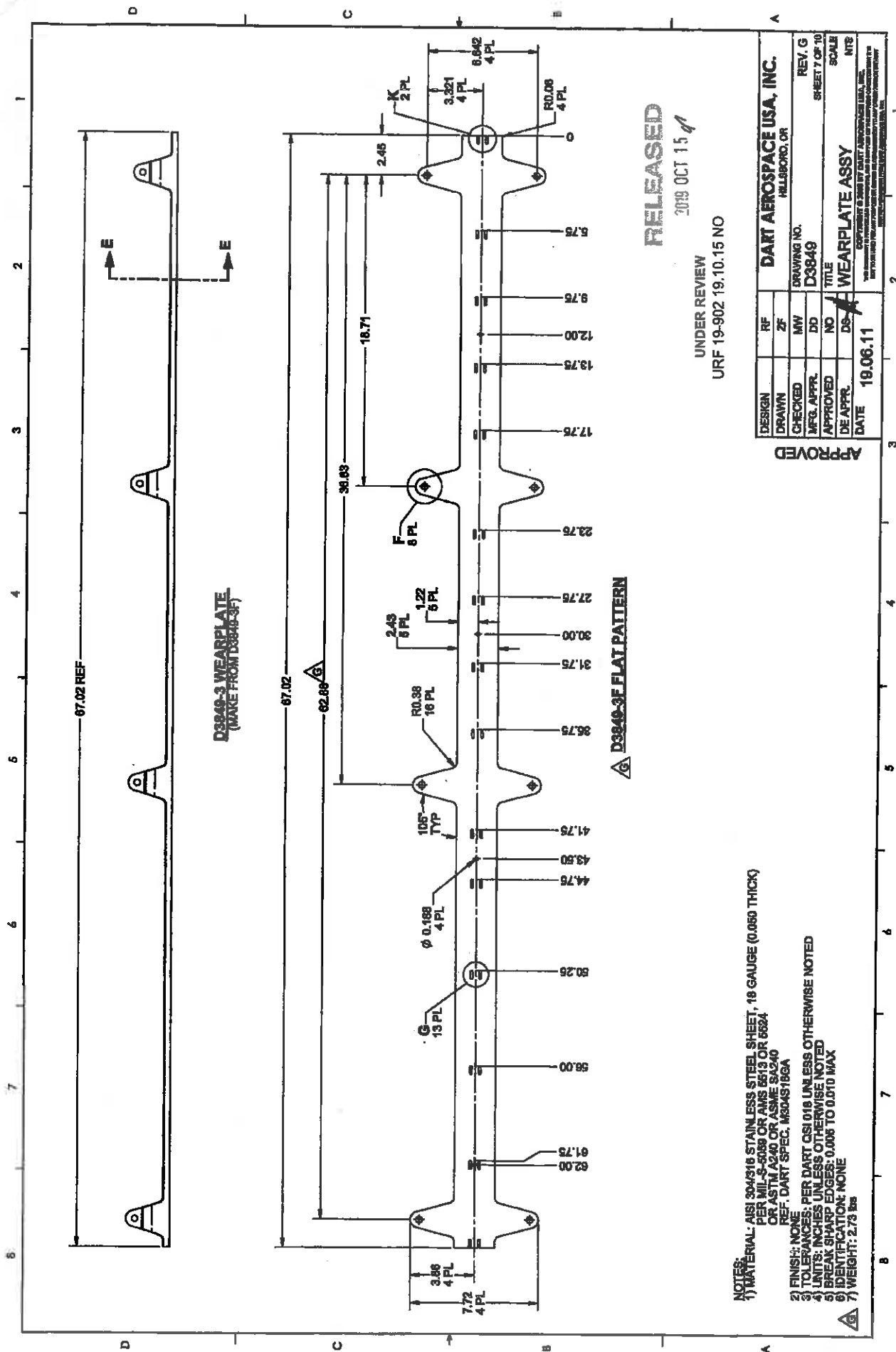
RELEASED
2019 OCT 15

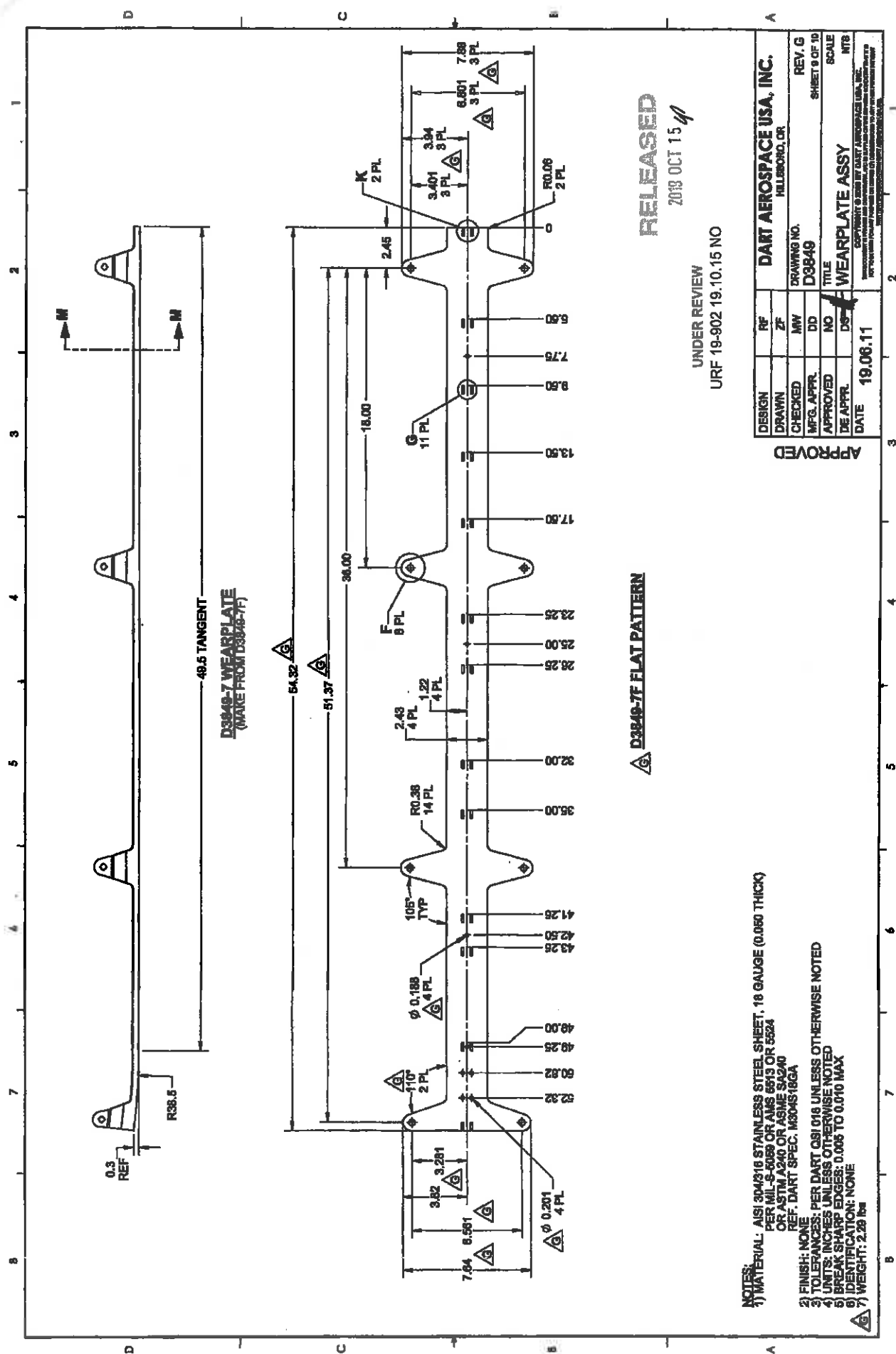
UNDER REVIEW
URF 19-902 19.10.15 NO

D3849-047 FWD WEARPLATE, FLOAT GEAR

SECTION D-D

APPROVED





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2013 OCT 15

UNDER REVIEW
URF 19-902 19.10.15 NO

D3848-7F FLAT PATTERN

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.060 THICK)
PER MIL-S-6068 OR AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA

2) FINISH: NONE
3) TOLERANCES: PER DART Q91 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.29 lbs

DESIGN	RF	REV. G
DRAWN	ZF	
CHECKED	MM	
INFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DG	
DATE	19.06.11	

APPROVED

DART AEROSPACE USA, INC.
HILLSDALE, OR

DRAWING NO. D3848
REV. G
SHEET 9 OF 10
SCALE NTS

WEARPLATE ASSY

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INSPECTION SHEET

DA
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0-89

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Date:

Revised by	
K.I	